

# Work Order ID 103850

\*103850\*

Page 1

July-03-13 9:27:37 AM

Item ID: D2565-211

D 2565-211

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

B 103850

Stop \*NS2\*

Item Name: Strut

Start Date: 7/03/13

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 7/16/13

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00

\*100\*

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr and polish

120

0.00

\*120\*

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

St 13/07/13

SN 12/07/13

⑥ 13-07-31 JD

1992

# Work Order ID 103850

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July-03-13 9:27:37 AM

Item ID: D2565-211

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Strut

Start Date: 7/03/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 7/16/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

\*130\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

Try + status - 5.3.15/02

150

Identify as per dwg & Stock Location: ST253A

0.00

\*150\*

Packaging

Memo

0.00

Packaging

6x M/c 13/08/01

6x d M 13/08/02

6x M.H. 13-08-2



Work Order ID 103850

\*103850\*

Page 3

July-03-13 9:27:37 AM

Item ID: D2565-211

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Strut

Start Date: 7/03/13 Start Qty: 6.00 \*6\*

Cust Item ID:

Required Date: 7/16/13 Req'd Qty: 6.00 \*6\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC21- Final Inspection - Work Order Release	0.00							
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\*160\*

QC

Memo

0.00

Quality Control

MJ 13-08-09

13-08-7



# Picklist Print

July-03-13 9:27:37 AM

Page 1

Work Order ID: 103850  
Parent Item: D2565-211  
Parent Item Name: Strut

Start Date: 7/03/13 Required Date: 7/16/13  
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP: D01.08.28Added Powder coat, and added Inspection level 3 and 21.SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049  
304 RD Tube .750 x .049W

Purchased No

100 838.2989

1.2 7.5789474

SB 13/07/13

Location

Loc Qty

Loc Code

MAT017

838.2988825

122312

13.3

122468

0.0000325

124768

83.93245

125068

52.0664

125513

289

M126183

400

8.5

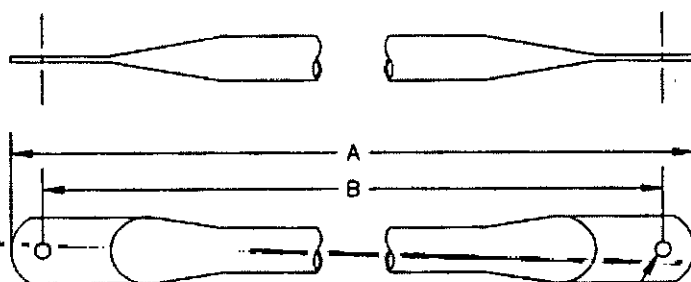




**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05 *[Signature]*



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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